



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3389-1

Job Sheet 176087



Part No: D3389-1

Job Qty: 5 ea

Part Name: Web



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-02-08 As per Rev C JLM IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		4/28/18	0.00	0.00	Start Up Skidtubes-1		M/L
100	Skidtubes	5 pcs		4/28/18	0.00	3.03	Skidtubes-3		DD M/L
110	QC	5 pcs		4/28/18	0.00	0.00	QC5		RE
120	HandFinish	5 pcs		4/30/18	0.00	1.08	HandFinish1		SA 18-04-19
130	QC	5 pcs		4/30/18	0.00	0.00	QC7-2		
140	Packaging	5 pcs		4/30/18	0.00	0.00	Packaging3-1		DAS APR 25 2018
150	QC21-SA	5 Ea		4/30/18	0.00	0.00	QC21		21

Part Op 100 - 1- Pick D2500-3-100 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut
Descriptions: line. 4- Cut to finished length 5- Open holes to finished size as per dwg D3389 6- Deburr
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100	Ext'n -I' Beam Web 4"	5 Ea (1 ea)	90-Start up Operation	5036056

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-3-100	5	75	0

Part Specifications

Specifications could not be found.

Plex 4/16/18 3:05 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ OTV Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

ed By _____

Supervisor
erification _____

Coordinator
approval _____

Container No: S062828

Part: D3389-1

Job No: 176087

Serial No/Batch: S062828

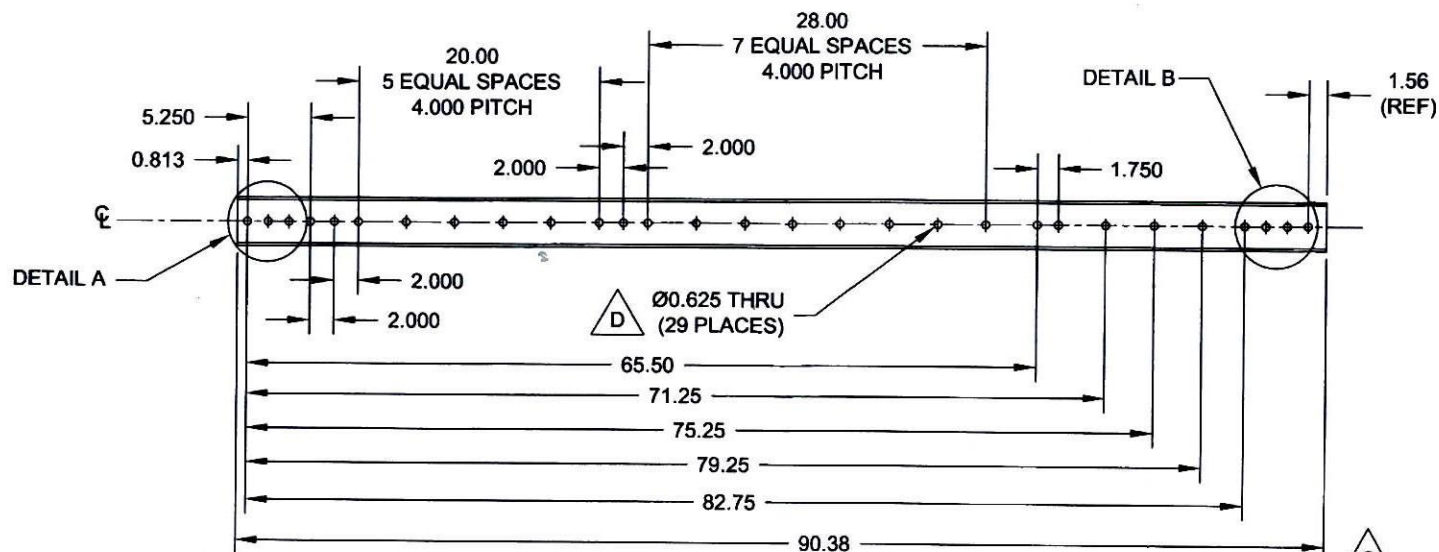
Revision: _____

Inspector: _____

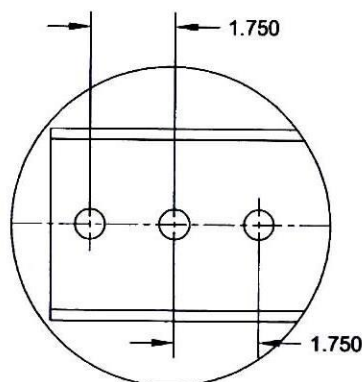
Dart Aerospace Ltd.
 1270 Aberdeen Street
 Newmarket, ON L4A 1K7
 CANADA
 TEL: 1 813 832-8200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 04/19/18

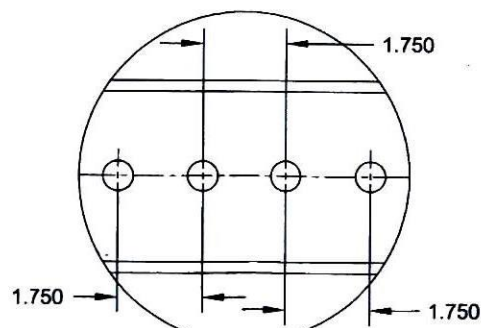
Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
		Pressure/For	☐
		Bending	☐
		Centre Not C	☐
		Cracks	☐
		Crimp/Kink/Ripple/Wave	☐
		Cuffs	☐
		Crushing	☐
		Heat Treat	☐
		Wave/Twist in Tube	☐
		Marks/Chatter	☐
		Inspection Incomplete/Unqualified	☐
		Contamination	☐
		Countersink	☐
		Cut Too Short	☐
		Instructions Incomplete/Unclear	☐
		Drill Holes	☐
		Out of Sequence	☐
		Off-set	☐
		Mislabeled	☐
		Fit/Function	☐
		Misaligned/off center	☐
		Part Moved	☐
		Drawing	☐
		Finish	☐
		Misread	☐
		Turning Sequence	☐
OTHER : _____			



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 140

D	REVISE HOLE DIAMETER FROM $\varnothing 0.257$ TO $\varnothing 0.625$, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3389 TITLE 412 WEB REV. D SHEET 1 OF 1 SCALE 1:10 COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMITS FROM DART AEROSPACE USA, INC.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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